

# Work Order ID 68618

Monday, April 18, 2011 3:31:47 PM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID:

Item Name: Back Frame Assembly

Stop



Start Date: 4/18/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MLF Date: 11-04-18 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3017	Rev B

100 Weld per dwg A/R 4130 rod Batch: M100075 0.00  
Large Fab



Large Fab

Memo

0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

EL 114-25

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

1 0 BE11/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3  Memo START TIME: 12:00 OVEN TEMPERATURE: 320° FINISH TIME: 12:30	0.00 0.00				1		BK 11-4-07	
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				1		11-4-07	

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
Packaging 	Memo <u>D 68626</u>	0.00	<u>SB</u>	<u>11/04/27</u>		<u>(1)</u>			
Packaging									
160 	QC21- Final Inspection - Work Order Release	0.00							
QC 	Memo	0.00							
Quality Control									

11/4/27 MF  
11-04-27

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 18, 2011 3:31:38 PM

Page 1

Work Order ID: 68618

Parent Item: D3017-041

Parent Item Name: Back Frame Assembly





Start Date: 4/18/2011

Required Date: 4/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A 01.09.19 New issue EC  
IPP RevB: as per revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.750W.083  4130 RD Tube .750 x.083W		Purchased	No			100	f	6.5800	2.458	2.587368			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				6.58					
					113812			6.58		3.98			
M4130NT0.750W.049  4130 RD Tube .750 x.049W		Purchased	No			100	f	85.2300	11.125	11.71053			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT033				85.23					
					10133			10.73					
					110740			74.5		9.66			
D3017-11  cap		Manufactured	No			100	Each	12.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA019				12					
					52583			12		2			
D3017-7  Lug		Manufactured	No			100	Each	13.0000	3	3			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA019				13					
					38567			2					
					52915			11		3			

W/O:		WORK ORDER CHANGES					
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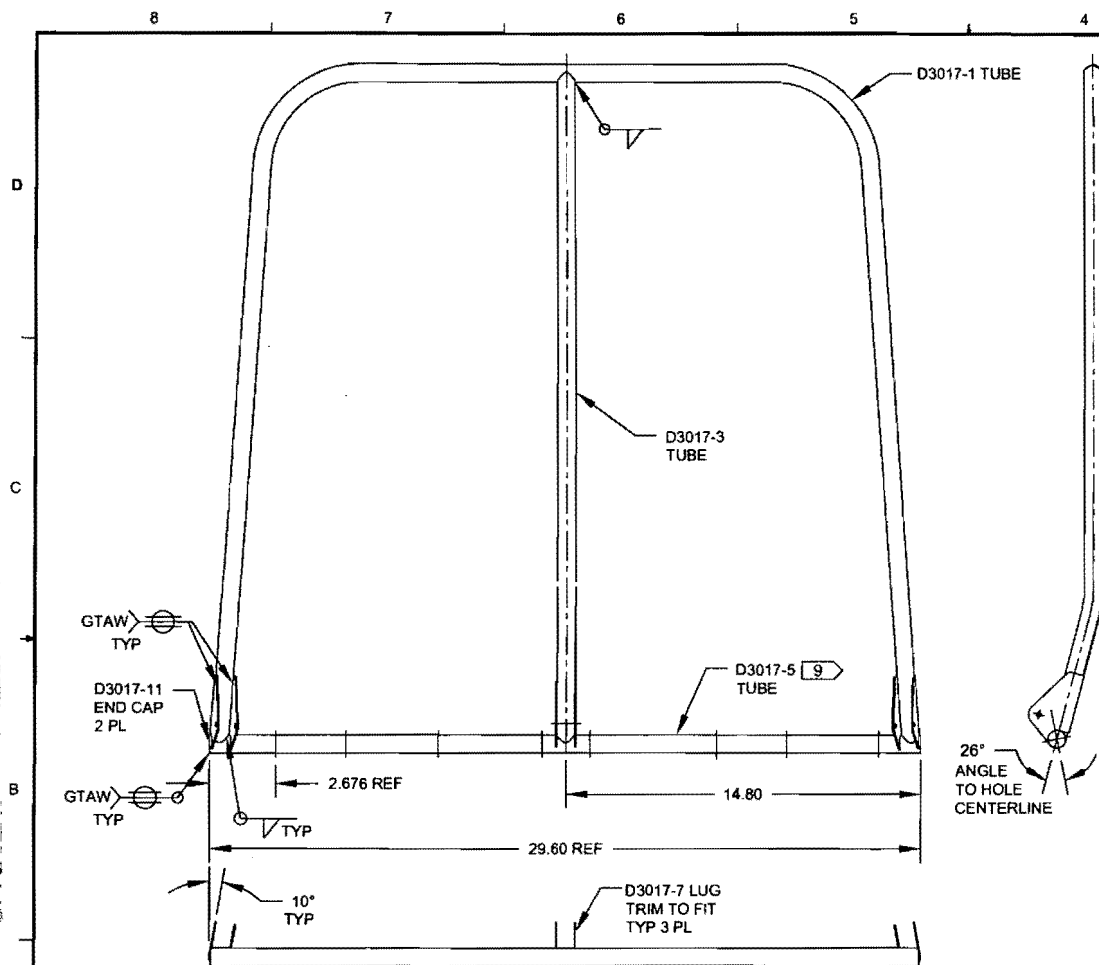
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**NOTE:** Date & initial all entries





ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP  
WITH D3023-1 BACK PANEL

26°  
ANGLE  
TO HOLE  
CENTERLINE

### D3017-041 BACK FRAME ASSEMBLY

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
D3017 SHEET 1 OF 4  
TITLE SCALE  
BACK FRAME ASSEMBLY NTS

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#68618

RELEASED  
2010-02-02  
WJP.

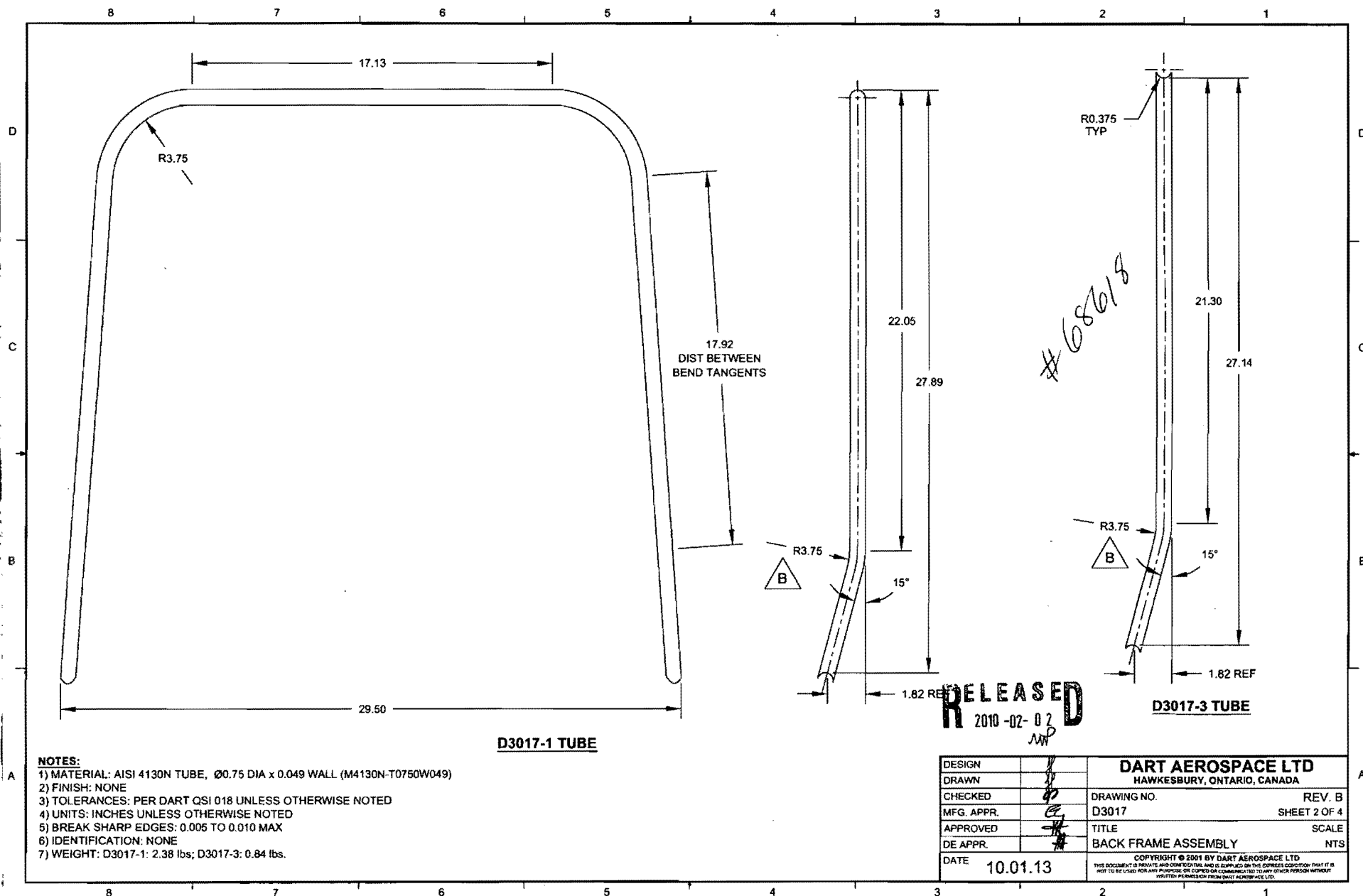
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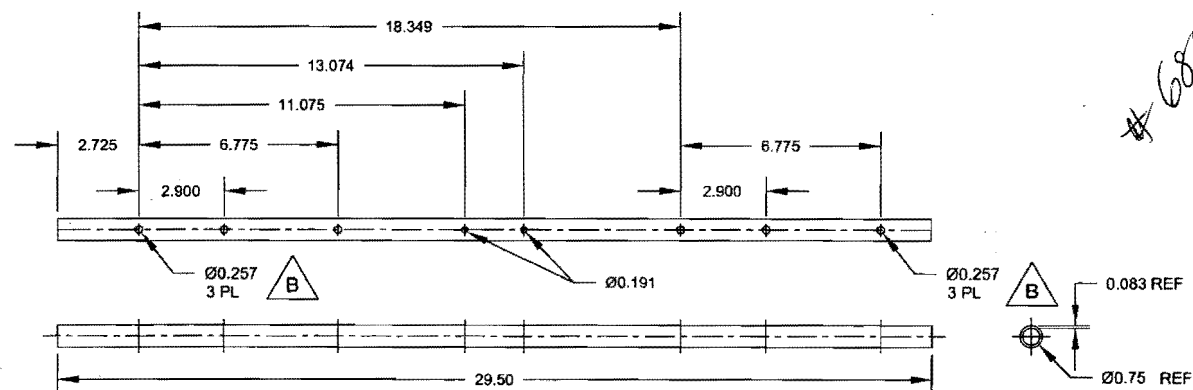
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**D3017-5 TUBE**

**RELEASED**  
2010-02-02

**NOTES:**

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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W/O:		WORK ORDER CHANGES					
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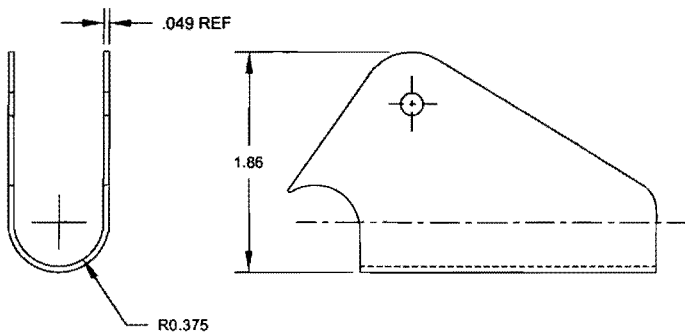
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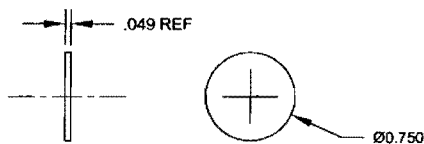
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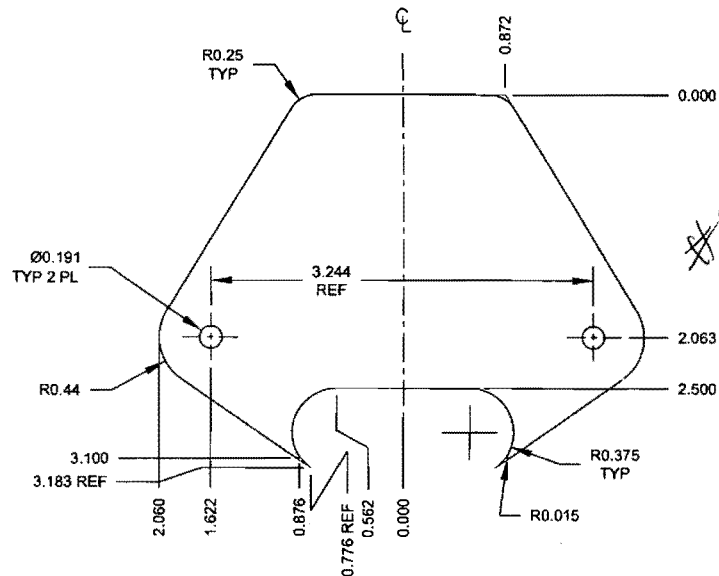
8 7 6 5 4 3 2 1



**D3017-7 LUG**  
BENDING DETAIL  
MAKE FROM D3017-7F



**D3017-11 END CAP**



**D3017-7F FLAT PATTERN**  
PART IS SYMMETRIC  
ABOUT CENTERLINE

**RELEASED**  
2010-02-02

**NOTES:**

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. B
CHECKED		D3017	SHEET 4 OF 4
MFG. APPR.		TITLE	SCALE
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8 7 6 5 4 3 2 1

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